

Date: Thursday, 5/4/2006 11:13:16 AM  
User: Kim Johnston

# Process Sheet

|                       |                                       |                  |                            |
|-----------------------|---------------------------------------|------------------|----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : COVER PLATE ASSEMBLY, LH |
| Job Number            | : 26949                               |                  |                            |
| Estimate Number       | : 12301                               |                  |                            |
| P.O. Number           | : N/A                                 | Part Number      | : D3467047                 |
| This Issue            | : 5/4/2006 S.O. No. : N/A             | Drawing Number   | : D3467 REV A              |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                      |
| First Issue           | : N/A Type : SMALL /MED FAB           | Drawing Revision | : A                        |
| Previous Run          | : 26604                               | Material         | : N/A                      |
| Written By            | : <i>SKK</i>                          | Due Date         | : 5/28/2006                |
| Checked & Approved By | : <i>KJ 06.05.05</i>                  | Qty:             | <i>8</i> Um: Each          |
| Comment               | : Est Rev: A New Issue 06-04.24 EC    |                  |                            |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |        |                |
|-----|--------|----------------|
| 1.0 | D34671 | COVER PLATE LH |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

|     |             |              |               |
|-----|-------------|--------------|---------------|
| Qty | Part Number | Description  | Batch         |
| 1   | D3467-1     | Shourd Plate | <i>B26629</i> |

|     |        |            |
|-----|--------|------------|
| 2.0 | D34677 | SEAL STRIP |
|-----|--------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 1   | D3467-7     | Doubler     | <i>B26983</i> |

*SB 06/06/03* (2)

|     |             |                               |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-047

*SB 06/06/03* (2)

|     |       |                 |
|-----|-------|-----------------|
| 4.0 | QC5/9 | WELD INSPECTION |
|-----|-------|-----------------|



Comment: WELD INSPECTION

*06.06.05* (2)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *SP*   Date:   06/06/07  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 5/4/2006 11:13:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, LH

Job Number: 26949

Part Number: D3467047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5747

6/6/06 (2)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/06 (2)

Job Completion



U 06/06/06

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

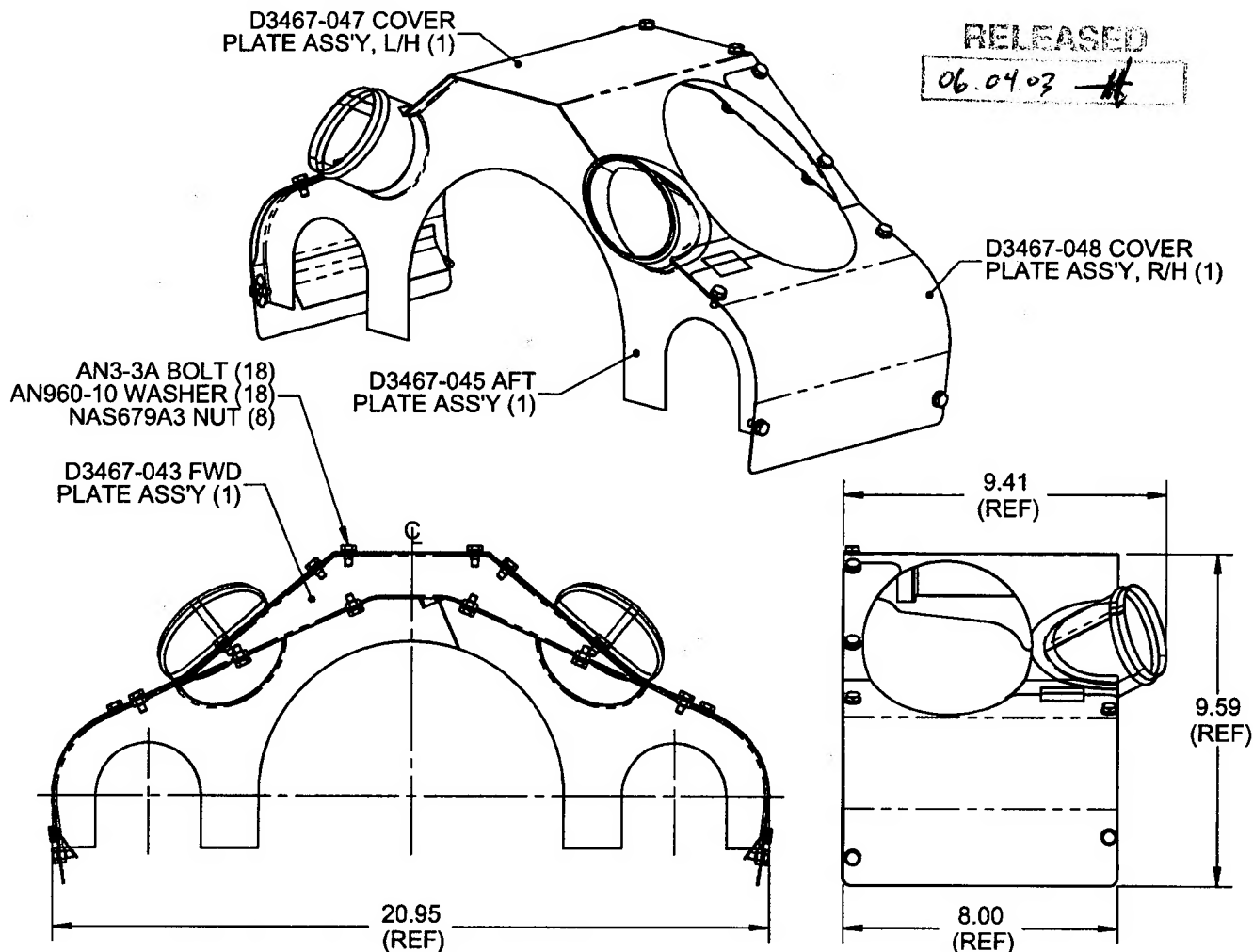
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |               |   |                         |
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| CHECKED<br>A     | APPROVED<br>H | DRAWING NO.<br>D3467                              | REV. A<br>SHEET 1 OF 15 |
| DATE<br>05.12.07 |               | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:5            |
| A                | 05.12.07      | NEW ISSUE   |                         |



### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N       | DESCRIPTION                    |
|-------------|-----------|--------------------------------|
| X           | D3467-041 | SHROUD ASSEMBLY                |
| 1           | D3467-043 | FWD PLATE ASSEMBLY             |
| 1           | D3467-045 | AFT PLATE ASSEMBLY SHOP COPY   |
| 1           | D3467-047 | COVER PLATE ASSEMBLY RETURN TO |
| 1           | D3467-048 | COVER PLATE ASSEMBLY RETURN TO |
|             |           | UNCONTROLLED COPY              |
| 18          | AN3-3A    | BOLT SUBJECT TO AMENDMENT      |
| 18          | AN960-10  | WASHER WITHOUT NOTICE          |
| 8           | NAS679A3  | NUT WORK ORDER                 |

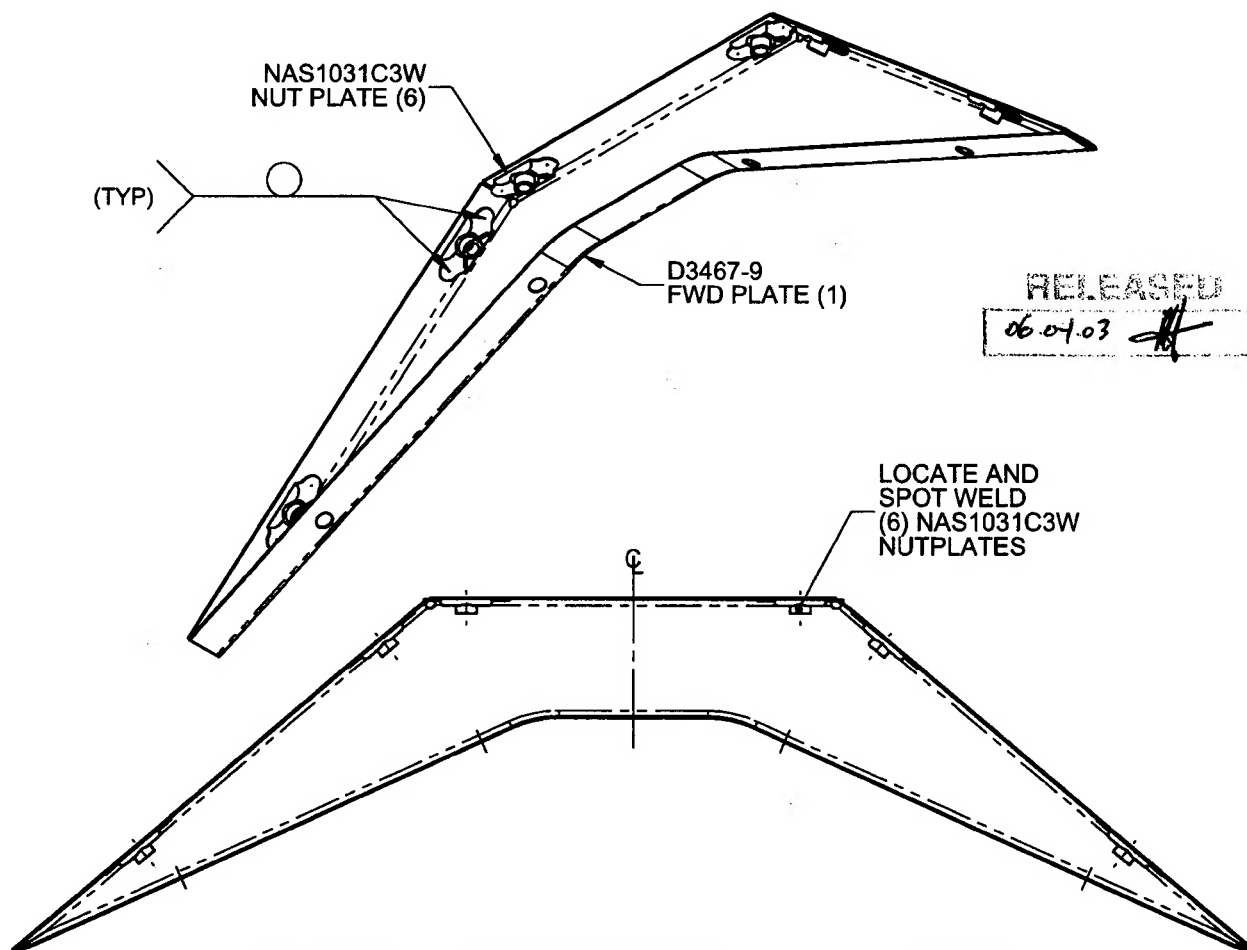
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| DATE<br><b>05.12.07</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:2            |



| QTY<br>-043 | P/N        | DESCRIPTION        |
|-------------|------------|--------------------|
| X           | D3467-043  | FWD PLATE ASSEMBLY |
| 1           | D3467-9    | FWD PLATE          |
| 6           | NAS1031C3W | NUT PLATE          |

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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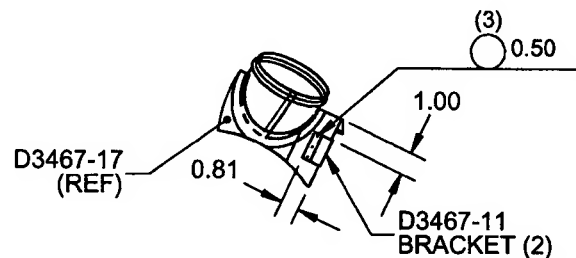
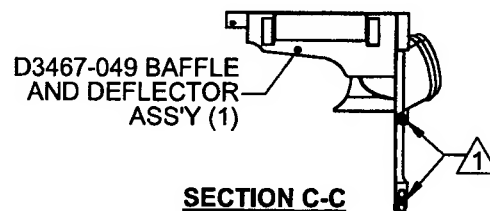
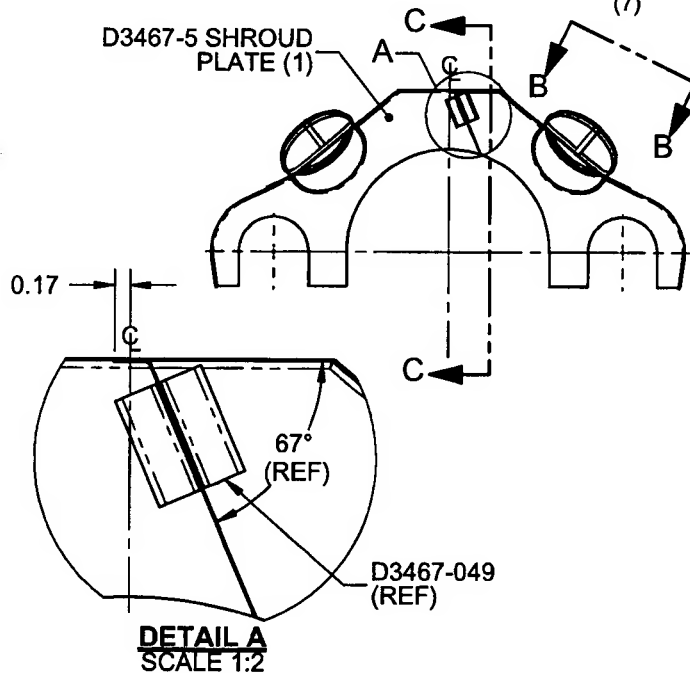
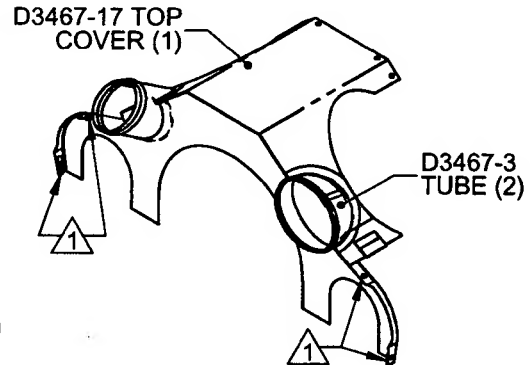
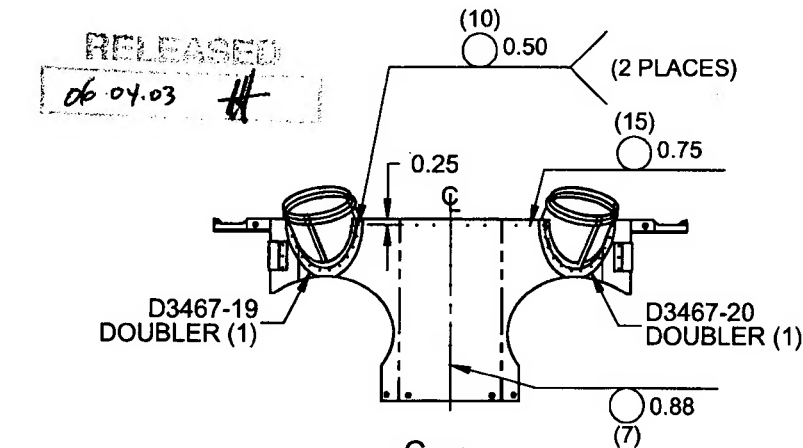
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| DATE<br><b>05.12.07</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SHEET 3 OF 15<br>SCALE<br>1:8 |

RELEASED

06 04.03



**VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)

### D3467-045 AFT PLATE ASSEMBLY

#### NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-045 | P/N        | DESCRIPTION                   |
|-------------|------------|-------------------------------|
| X           | D3467-045  | AFT PLATE ASSEMBLY            |
| 1           | D3467-049  | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2           | D3467-3    | TUBE                          |
| 1           | D3467-5    | SHROUD PLATE                  |
| 2           | D3467-11   | BRACKET                       |
| 1           | D3467-17   | TOP COVER                     |
| 1           | D3467-19   | DOUBLER                       |
| 1           | D3467-20   | DOUBLER                       |
| 4           | NAS1031C3W | NUT PLATE                     |

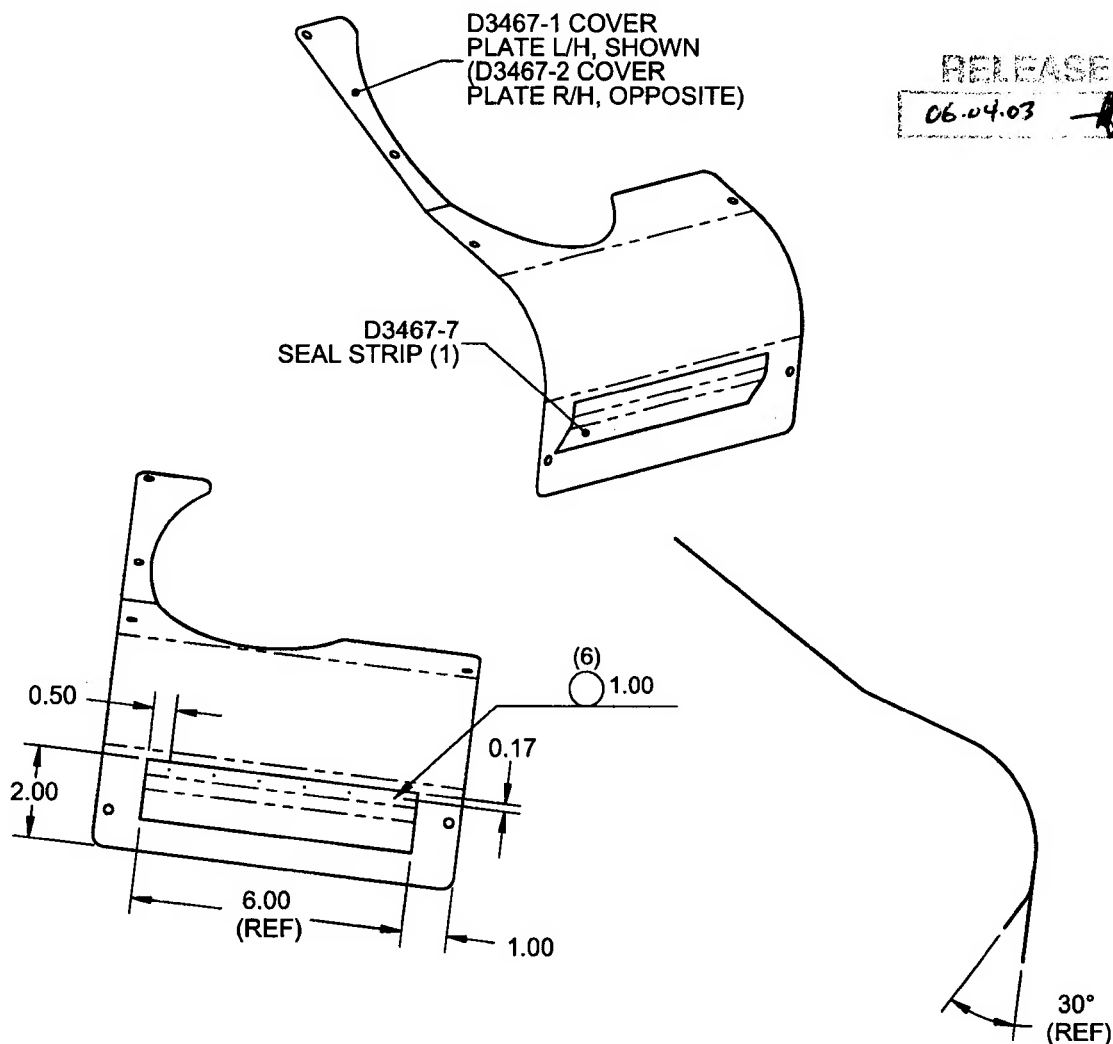
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| DATE<br>05.12.07              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |



**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-047 | QTY<br>-048 | P/N       | DESCRIPTION               | RETURN TO<br>ENGINEERING |
|-------------|-------------|-----------|---------------------------|--------------------------|
| X           |             | D3467-047 | COVER PLATE ASSEMBLY, L/H | CONTROLLED COPY          |
|             | X           | D3467-048 | COVER PLATE ASSEMBLY, R/H | SUBJECT TO AMENDMENT     |
| 1           |             | D3467-1   | COVER PLATE, L/H          | WITHOUT NOTICE           |
|             | 1           | D3467-2   | COVER PLATE, R/H          | WORK ORDER               |
| 1           | 1           | D3467-7   | SEAL STRIP                | NO. 26944                |

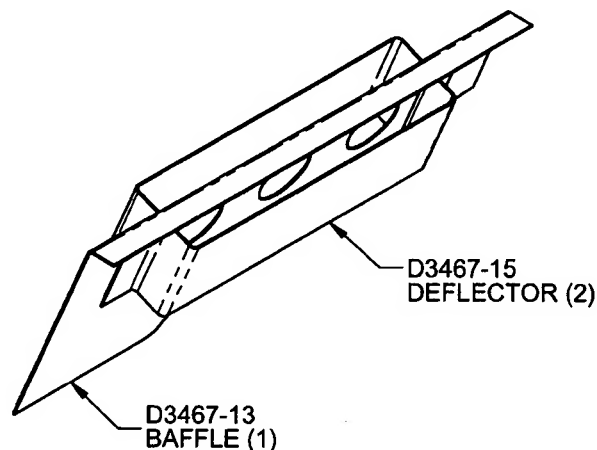
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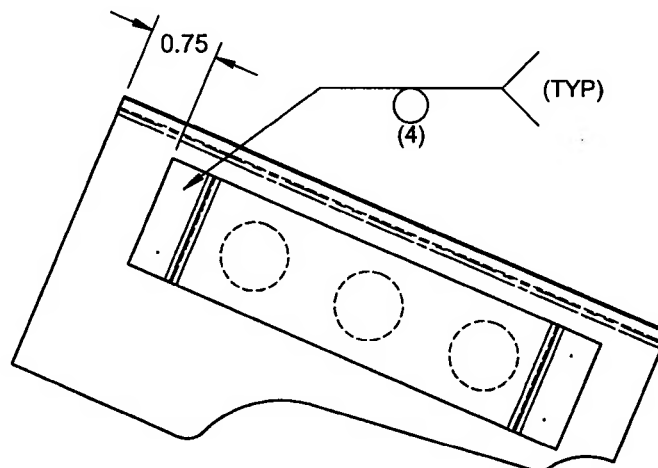
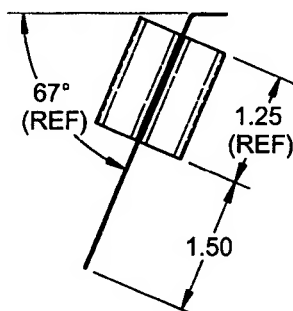




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| DATE<br>05.12.07 |               | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:2            |



RELEASED  
06.04.03 H



### D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-049 | P/N       | DESCRIPTION                 | REVISION |
|-------------|-----------|-----------------------------|----------|
|             | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |          |
| 1           | D3467-13  | BAFFLE                      |          |
| 2           | D3467-15  | DEFLECTOR                   |          |

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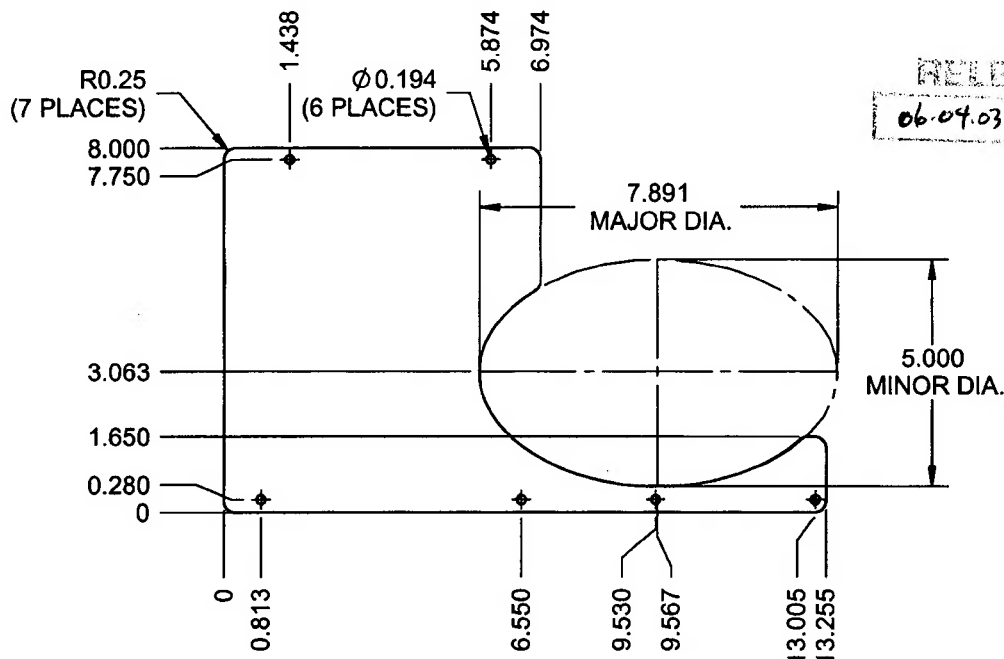
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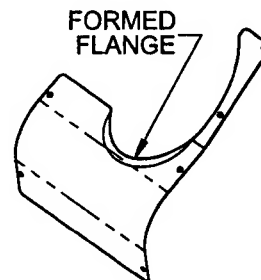
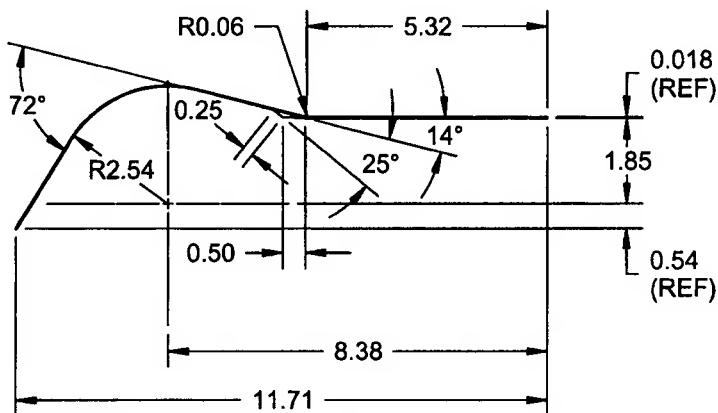
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| DATE<br>05.12.07              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |



### D3467-1F COVER PLATE FLAT PATTERN



### D3467-1 L/H COVER PLATE D3467-2 R/H COVER PLATE (OPPOSITE)

### D3467-1 L/H COVER PLATE ISOMETRIC VIEW D3467-2 R/H COVER PLATE (OPPOSITE)

SCALE 1:8 SHOP COPY

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

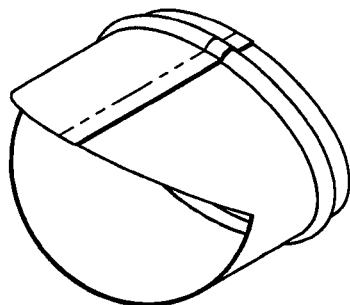
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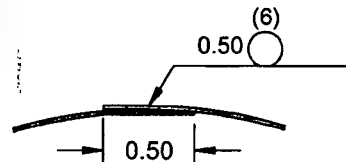
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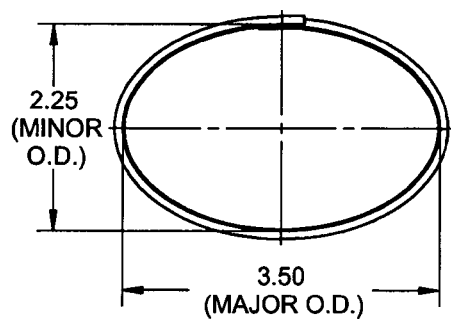
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| DATE<br><b>05.12.07</b> | TITLE<br><b>SHROUD ASSEMBLY</b> |  | SCALE<br>1:2            |



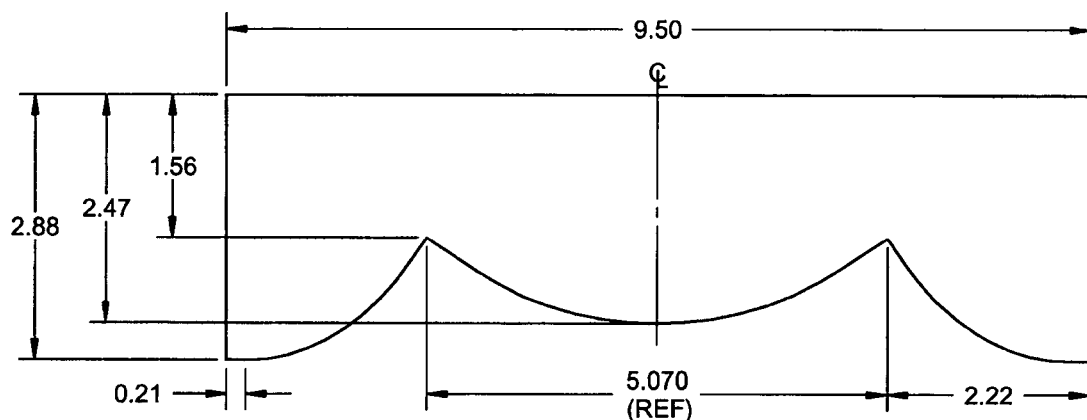
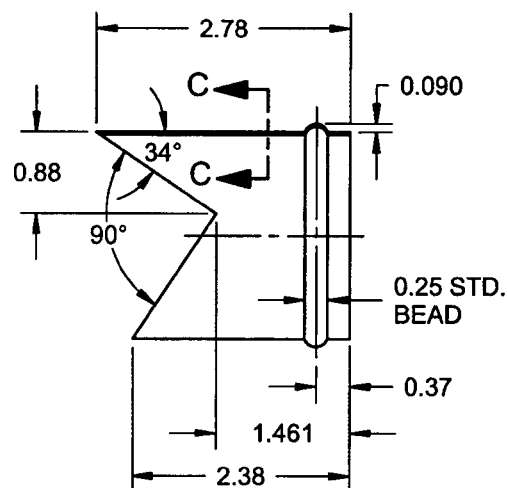
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**SECTION C-C**  
SCALE 1:1



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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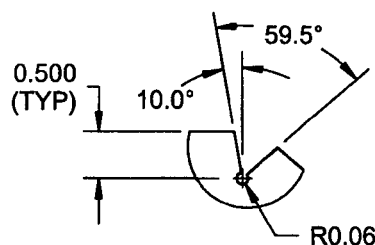
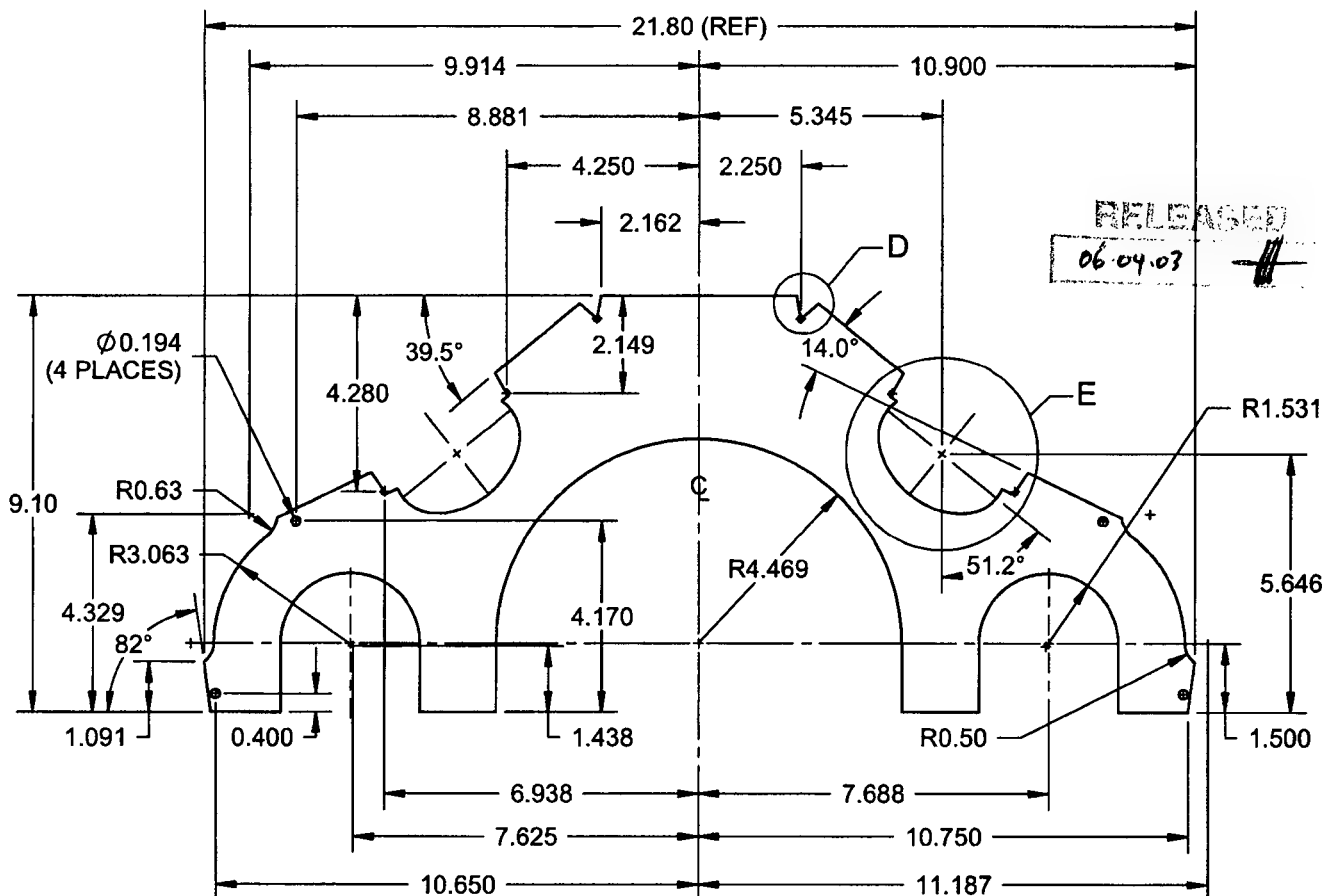
WORK ORDER  
NO. **26949**

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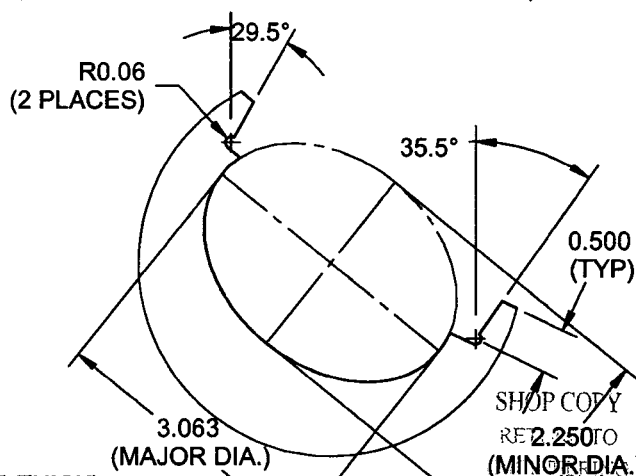
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| DATE<br>05.12.07              |                                | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:8            |



**DETAIL D**  
SCALE 1:2



**DETAIL E**  
SCALE 1:2  
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### **D3467-5F AFT PLATE FLAT PATTERN**

#### **NOTES:**

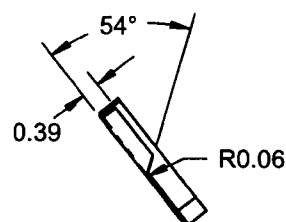
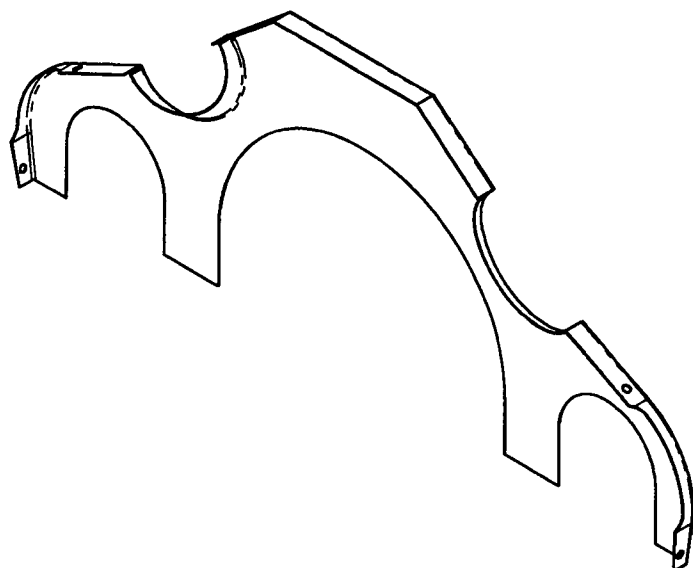
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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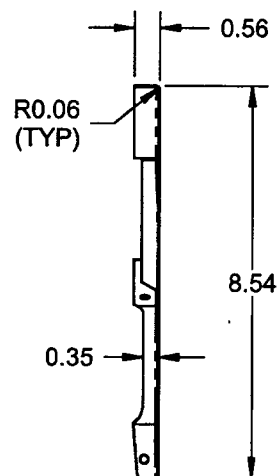
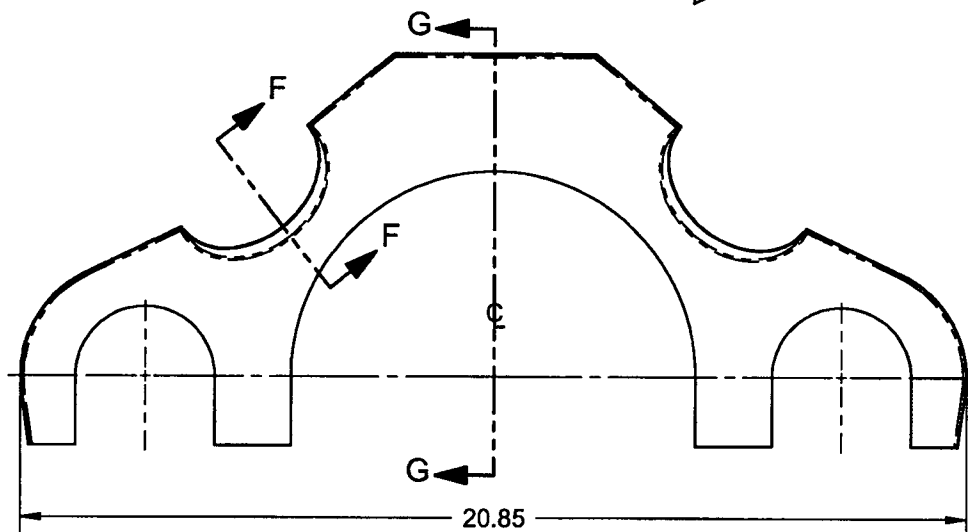
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| DATE<br>05.12.07 |               | TITLE<br>SHROUD ASSEMBLY                          | SCALE<br>1:4            |



**SECTION F-F**



**SECTION G-G**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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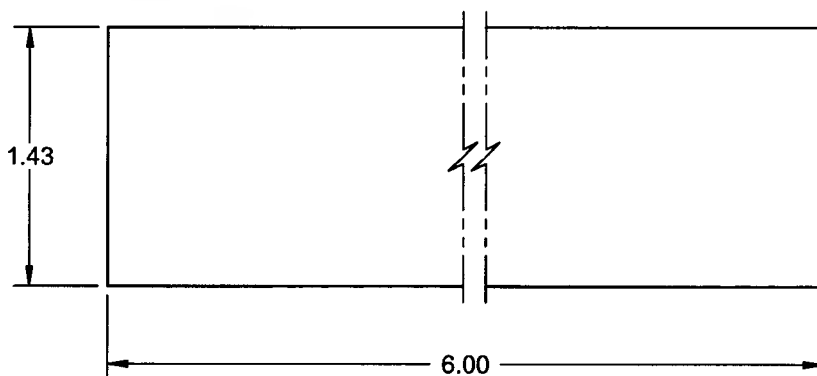
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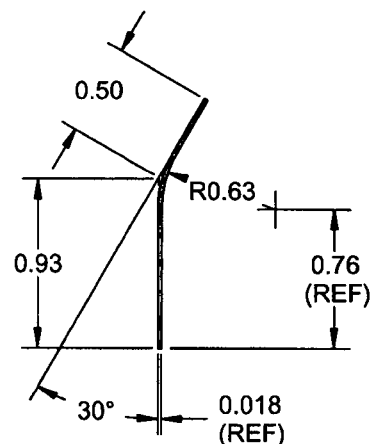


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| DATE<br><b>05.12.07</b>       |                                | TITLE<br><b>SHROUD ASSEMBLY</b>                          | SCALE<br>1:1             |

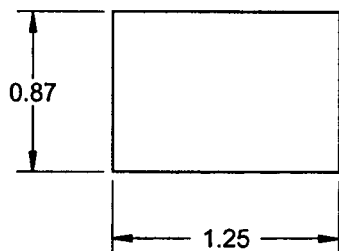
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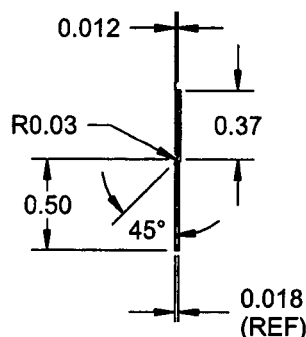
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

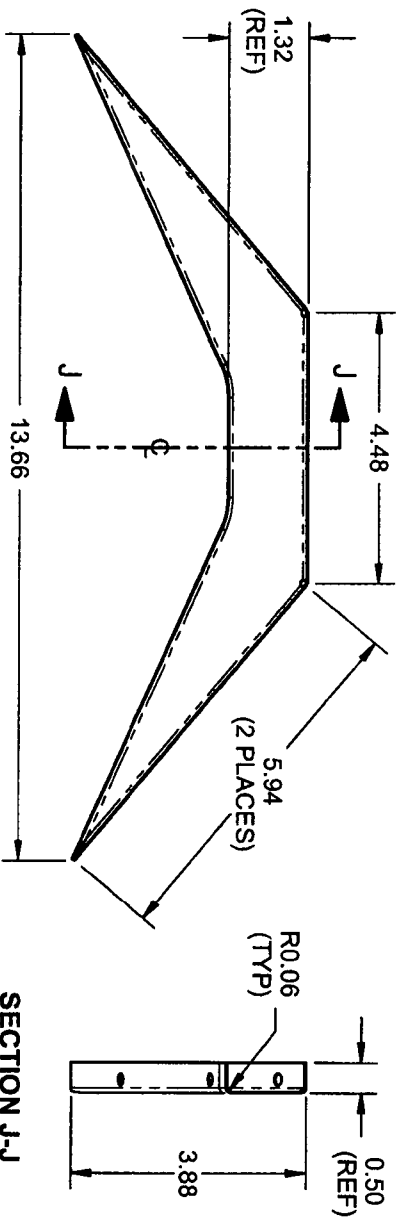
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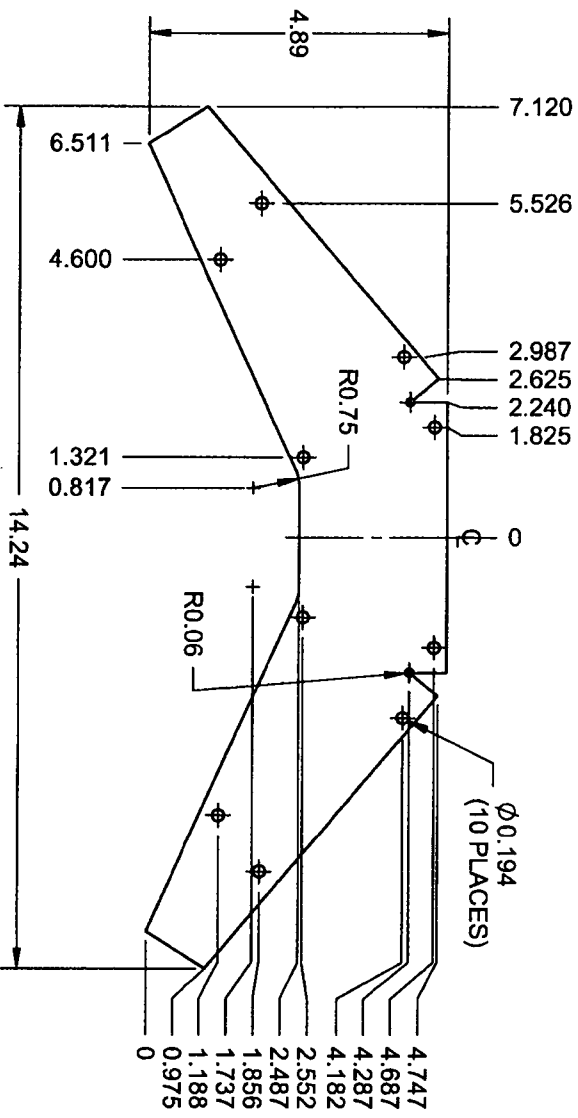
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| DATE     |          | REV. A<br>SHEET 11 OF 15                                 |
| 05.12.07 |          | SCALE 1:3  |
|          | TITLE    | SHROUD ASSEMBLY  |



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH ROLLIED COPY 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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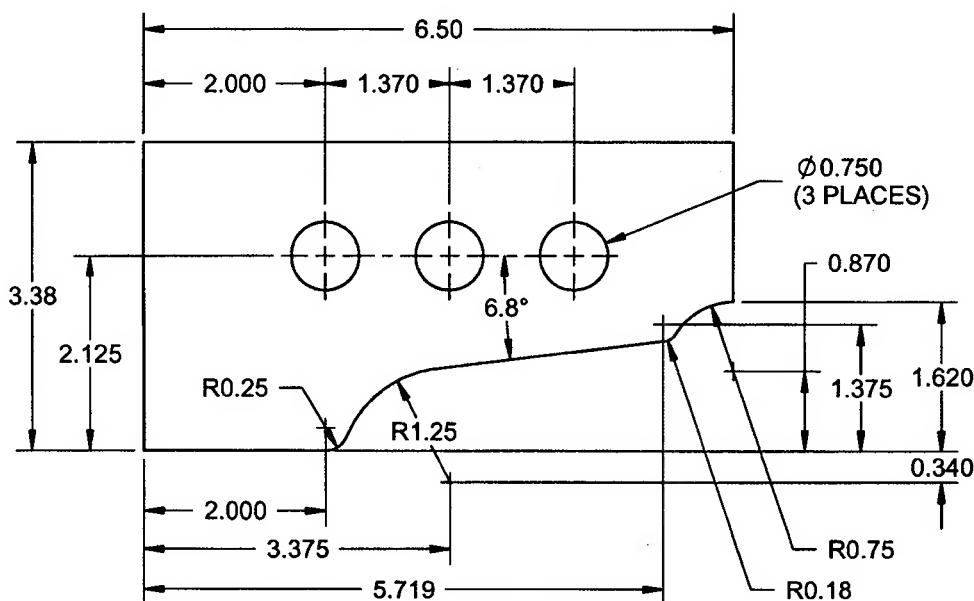
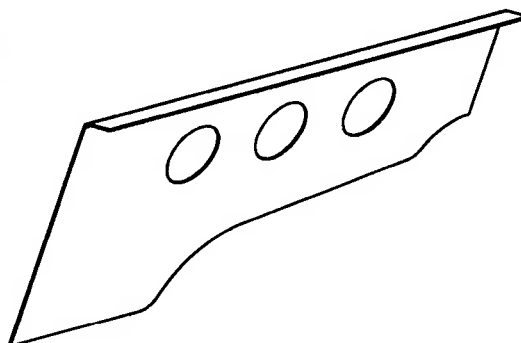
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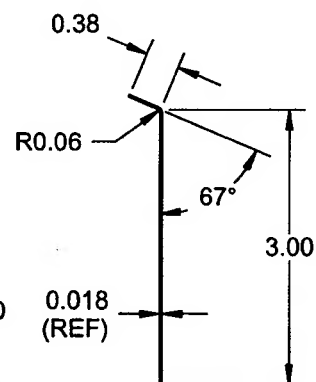


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| DATE<br>05.12.07 |               | TITLE<br>SHROUD ASSEMBLY                          | SHEET 12 OF 15<br>SCALE<br>1:2 |

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**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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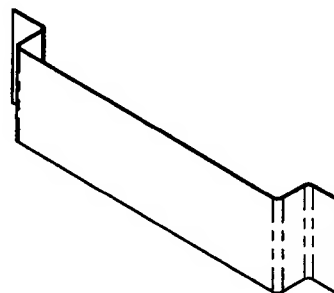
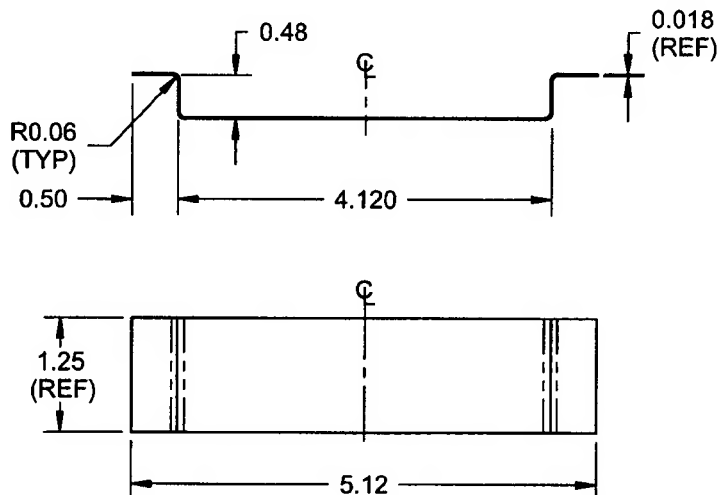
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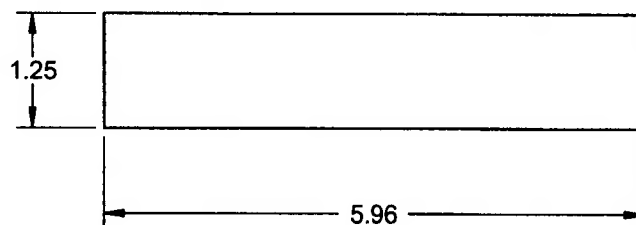


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### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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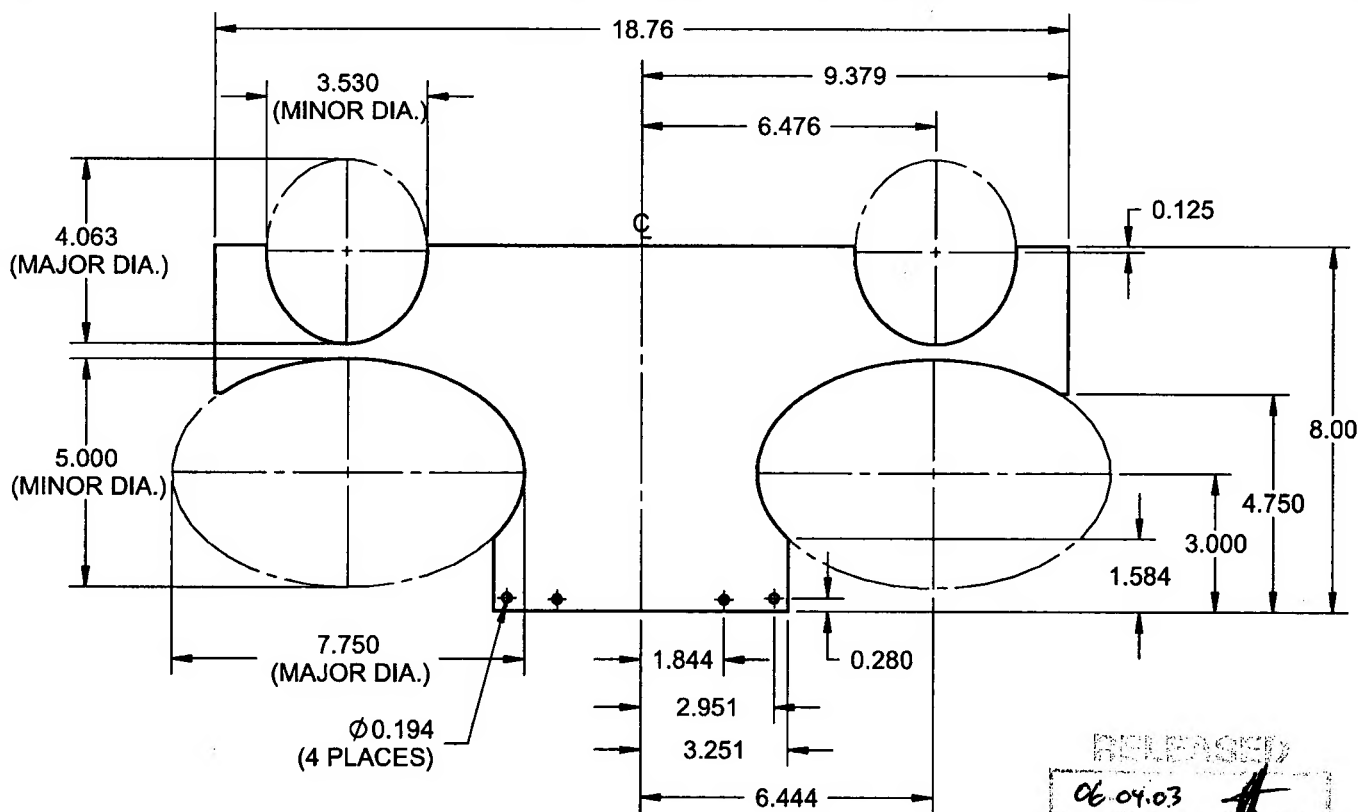
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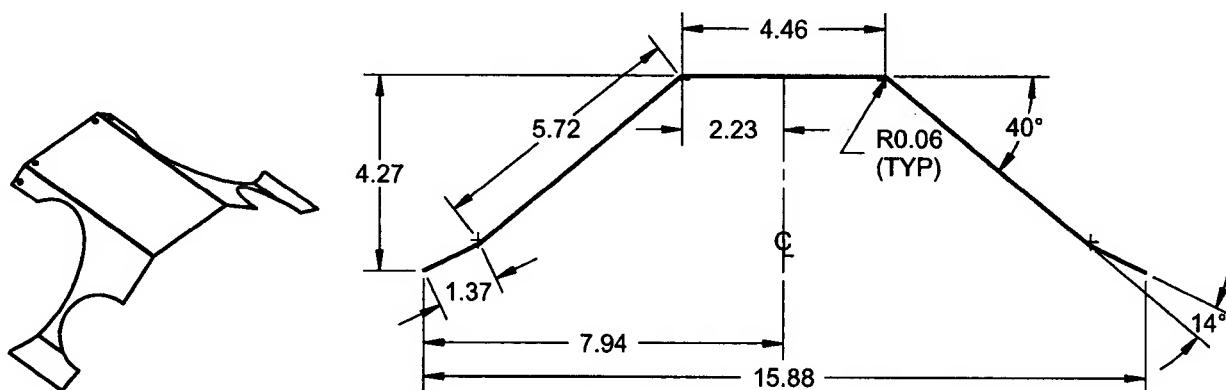




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| DATE<br>05.12.07              |                                | TITLE<br>SHROUD ASSEMBLY                          | SHEET 14 OF 15<br>SCALE<br>1:4 |



**D3467-17F TOP COVER FLAT PATTERN**



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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